

Date: 11/9/2006 4:37:32 PM
User: John Johnston

Process Sheet

split
SB 07/01/15

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 29391		
Estimate Number	: 11029		
P.O. Number	: N/A	Part Number	: D2803041
This Issue	: 11/9/2006 S.O. No. : N/A	Drawing Number	: D2803 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 29155	Material	: N/A
Written By	: <u>JA 061110</u>	Due Date	: 11/27/2006
Checked & Approved By	: <u>JA 061110</u>	Qty:	15 Um: Each
Comment	: EST F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28031	STA 84 Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

STA 84 BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D2803-1	Bracket	B28414

x7

ml

2.0	D28051	Stop
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

STOP

Pick:

Qty	Part Number	Description	Batch
1	D2805-1	Stop	B29405

x7

ml

3.0	D2809	Bushing
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B28645

x7

x7

Press D2805-1 into arm as per Dwg D2803

ml or p. 1/16

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/04/18

te: Thursday, 11/9/2006 4:37:32 PM
ser: King Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 29391

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL/Y

07/01/19

(7)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/01/22

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

(done on step 3)

ml 07/01/16

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

M100564 x 14

ml

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

M102545 x 14

ml

10.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 NAS1515H3 Washer

M100993

x 28

A/R LPS-3

Corrosion Spray

M101472

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

ml

ite: Thursday, 11/9/2006 4:37:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 29391

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2803.

ml 07/01/22 x7

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/23 (7)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *57158*

07/01/24 (7)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



07/01/25 (7)

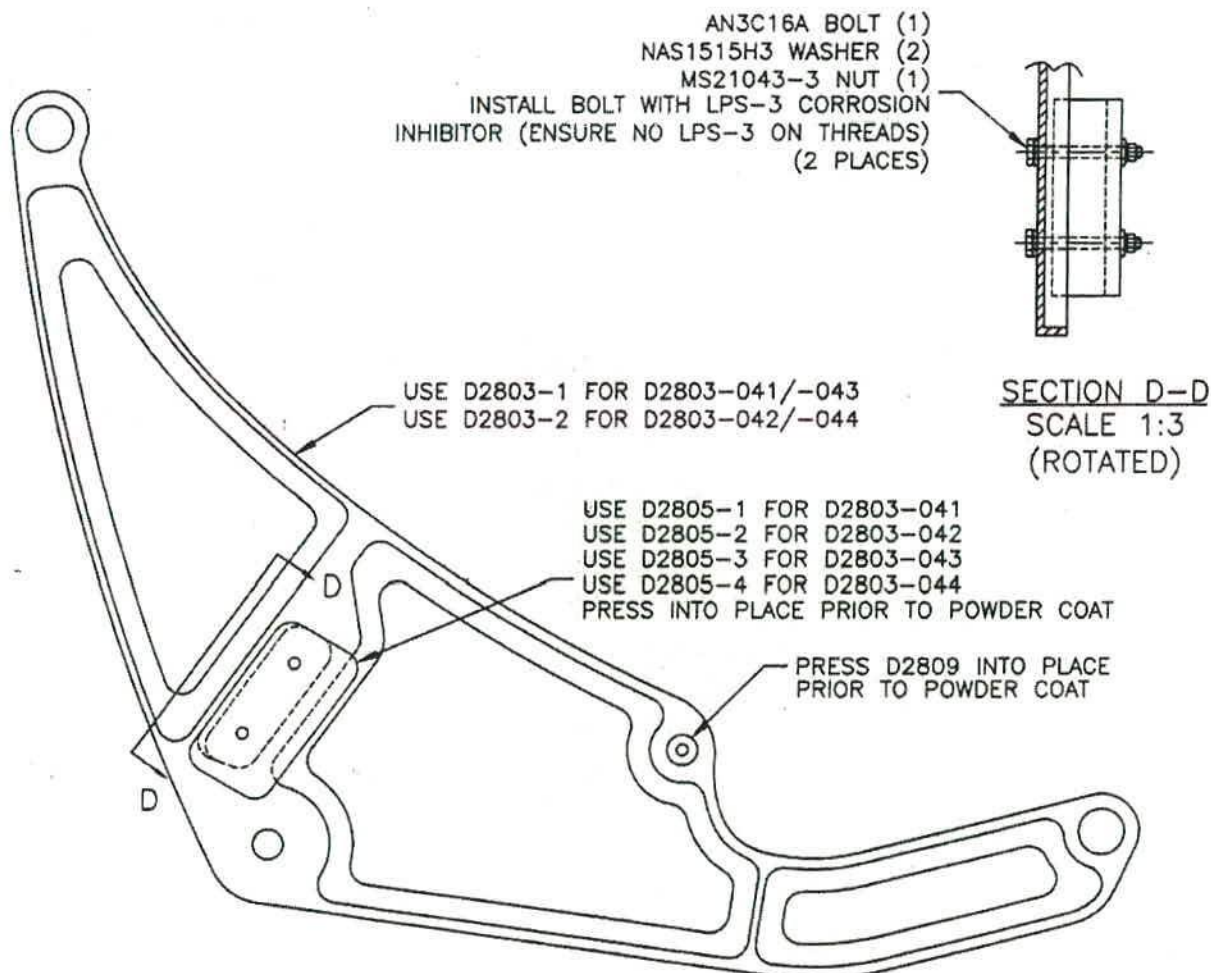
Job Completion



07.01.25

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
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05.03.11 SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29391

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